

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012320**Date Inspected:** 02-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**TRIAL ASSEMBLY YARD****MAGNETIC PARTICLE INSPECTION**

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6east Designation are as follows.

SP528-001-099~108; SP568-001-085~086

SEG028J-065, 68, 88~091

SEG032H-065, 068, 088~091

This QA Inspector randomly observed the following work in progress.

**OBG SEGMENT 7BW**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067752 performing Shielded Metal Arc Welding process for weld SEG035A-005 located on PCMK weld between side panel and bottom panel (cross

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## WELDING INSPECTION REPORT

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beam side). ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

### OBG SEGMENT 6BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037932 performing Shielded Metal Arc Welding process for weld 006 located on PCMK OBW6F. ZPMC QC Mr. Zhang Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

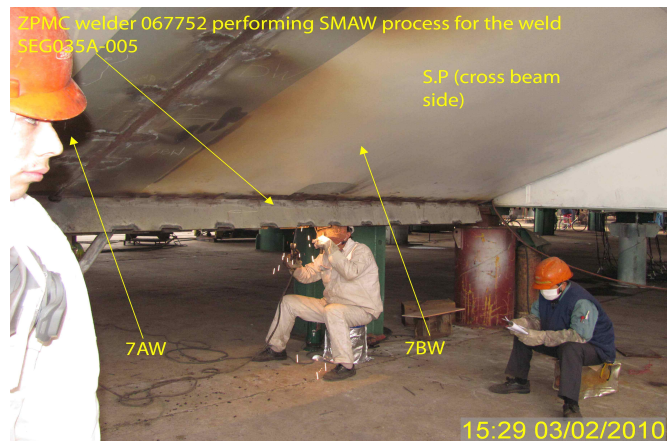
### OBG SEGMENT 6AE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 048659 performing Shielded Metal Arc Welding process for weld 038 located on PCMK SSD16- PP035. ZPMC QC Mr. Wang Yang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

### OBG SEGMENT 6BW-6CW

This Quality Assurance (QA) Inspector observed ZPMC Inspector performing Magnetic Particle Inspection on the hold back weld between side panel and "T" stiffener (counter weight side) near the side panel splice weld between OBG segment 6BW and 6CW.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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Inspected By: Utekar, Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer